



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6510G06531-6F-3

Job Sheet 199052



Part No: RBW6510G06531-6F-3

Job Qty: 6 pcs *7 pcs. B.a*

Part Name: Support #2



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/12/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/21/19

Description:

Type: SOLD

Note: DWG RBW6510G06531-6F Rev A IPP Rev. A 19.08.06 New Issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
50	Bandsaw - 1	6 pcs		10/21/19	0.00	0.00	Bandsaw - 1		<i>SL 19-10-15</i>
60	Outsource - 1 - Heat Treat	6 pcs		10/21/19			ATL002-VC <i>MEI001</i>		<i>HA 2019-10-16</i>
70	Packaging 2-2 - Receive - B4B	6 pcs		10/21/19	0.00	0.00	Packaging 2 - 1 - B4B		<i>DP 2019 5 0 AON</i>
80	QC 6	6 pcs		10/21/19	0.00	0.00	QC 6 - 40	<i>DAS 81 9-89</i>	<i>NOV 0 5 2019</i>
100	SL-2500Y - 1	6 pcs		10/21/19	1.00	6.00	SL-2500Y - 1		<i>SL 19-11-8</i>
110	QC 2	6 pcs		10/21/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		<i>SL</i>
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		

Plex 10/15/19 10:16 AM dart.lussier.patrick

10/15/2019

[Dart Hawkesbury] Job Sheet - Lussier, Patrick

					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	NV5000 - 1 - B4B	6	10/21/19	1.00 12.00	NV5000 - 1 - B4B	
	pcs				NV5000 - 2 - B4B	S.C.L.
130	QC 2	6	10/21/19	0.00 0.00	QC 2 - 1	
	pcs				QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	S.C.L. (4-11-15)
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	6	10/21/19	0.00 0.00	QC 8 - 12	
	pcs				QC 8 - 14	Am 19/10/14
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	

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					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
150	Outsource - 12 - Black Oxide	6 pcs	10/21/19		GRO002-VC	2019-11-18
160	Packaging 2-1 - Receive - B4B	6 pcs	10/21/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	DP NOV 25 2019
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
170	QC 6	6 pcs	10/21/19	0.00 0.00	QC 6 - 9	DAS
					QC 6 - 68	NOV 26 2019 68
					QC 6 - 61	9-89

				QC 6 - 40		
				QC 6 - 81		
180	Packaging 3-1 - Stock - B4B	6	10/21/19	0.00	0.00	Packaging 3 - 1 - B4B
		pcs				Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B
						Packaging 3 - 4 - B4B
						Packaging 3 - 5 - B4B
						Packaging 3 - 6 - B4B
						Packaging 3 - 7 - B4B
						Packaging 3 - 8 - B4B
						Packaging 3 - 9 - B4B
						Packaging 3 - 10 - B4B
						Packaging 3 - 11 - B4B
						Packaging 3 - 12 - B4B
						Packaging 3 - 13 - B4B
						Packaging 3 - 14 - B4B
						Packaging 3 - 15 - B4B
						Packaging 3 - 16 - B4B
						Packaging 3 - 17 - B4B
						Packaging 3 - 18 - B4B
						Packaging 3 - 19 - B4B
						Packaging 3 - 20 - B4B
						Packaging 3 - 21 - B4B
						Packaging 3 - 22 - B4B
						Packaging 3 - 23 - B4B
						Packaging 3 - 24 - B4B
						Packaging 3 - 25 - B4B
						Packaging 3 - 26 - B4B
						Packaging 3 - 27 - B4B
						Packaging 3 - 28 - B4B
						Packaging 3 - 29 - B4B
						Packaging 3 - 30 - B4B
						Packaging 3 - 31 - B4B
						Packaging 3 - 32 - B4B
						Packaging 3 - 33 - B4B
						Packaging 3 - 34 - B4B
						Packaging 3 - 35 - B4B
						Packaging 3 - 36 -

MLL

190 QC 21 - SA	6 pcs	10/21/19	0.00	0.00	B4B	QC 21 - SA - 21	DAS 21 308	NOV 26 2019
						QC 21 - SA - 70		
						QC 21 - SA - 53		

Part Op 50 - CUT BLANK TO SIZE (2.65")

Descriptions: 60 - 1-Issue P/O; 44781 Heat treat RC 28-32 2-Bead blast 3-Material type; 4140 4-Certificate of Conformity is required

100 - 1-Machine as per folio FC 995 FOLIO REV: AA DWG REV: A 2-Deburr

110 - QC2- Inspect parts off machine FAI/FAIB

120 - 1-Machine as per folio FC 994 FOLIO REV: AA DWG REV: A 2-Deburr

130 - (QC2- Inspect parts off machine FAI/FAIB)

150 - Issue P/O; 45129 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required

160 - Certificate of Conformity is required

170 - QC6- All purchased or subcontracted products

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

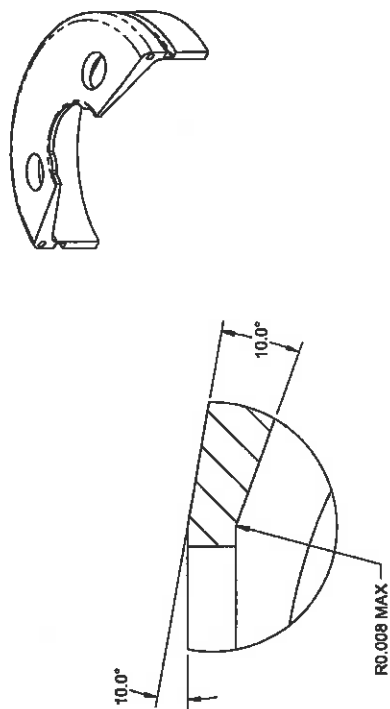
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R7.500	ALSI 4140 Round Bar 7.500" Dia. CUT TO SIZE: 2.650"	1.4400 ft (.24 ea)	100-SL-2500Y - 1	<u>S218341</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-SL-2500Y - 1	MT-4140QT-R7.500	1	6	0

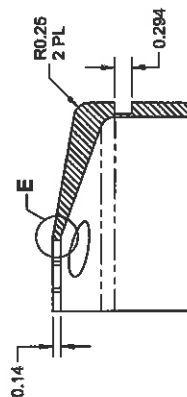
Part Specifications	
Specifications could not be found.	

GA
173

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SECTION D-D



RBW6510G06531-6F-3 SUPPORT #2

DESIGN	KPT	TOOL PART #	REV. A	SCALE	NTS
DRAWN	KPT	RBW6510G06531-6F	SHEET 4 OF 7		
CHECKED	VLM	TITLE			
MFG. APPR.	JFC	OUTER ADAPTER INSTL. TOOL			
APPROVED					
DATE	2019-07-04				

NOTES:
1) MATERIAL: 4140 (28-32 RC)

1) MATERIAL: 4140 (28-32 RC.)
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-18173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81308 AND WIPE OFF EXCESS

4) TOLERANCES: X.X = $\pm 0.1^{\circ}$ / $\pm 0.1^{\circ}$
X.XX = $\pm 0.01^{\circ}$ / $\pm 0.5^{\circ}$
X.XXX = $\pm 0.001^{\circ}$ / $\pm 0.04^{\circ}$

X,XX = ± 0.01 / ± 0.03
X,XXX = ± 0.005 / ± 0.1
X,XXXX = ± 0.0025 / ± 0.05

 $X_{XXXX} = \pm 0.005^\circ \quad / \quad \pm 0.05^\circ$

$\chi^2_{\text{dof}} = +1/-0.0005$ / $+1/-0.05$
PARALLELISM, ECCENTRICITY A

5) UNITS: INCHES UNLESS OTHERWISE NOTED

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A

7) IDENTIFICATION: N/A

7 8

10

750

27.

11-2-5

3

11/2, 995

16/11/19

11

•

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐				DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐				Date: _____ Sequence #: _____		QTY Affected: _____		MRB (QSI042) _____	
Description Work Order Deviation						Disposition									
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐						FAULT CATEGORY									
						Pressure/Forced Bending ☐ ☐ ☐ ☐ ☐ Crushing ☐ ☐ ☐ ☐ ☐ Cracks ☐ ☐ ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ ☐ ☐		Contamination Misaligned/off center ☐ ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐ ☐		Power Loss/Surge ☐ ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐ ☐		Positioned Wrong ☐ ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐ ☐			
						Other/Details: _____									
						Completed By _____						Lead hand / Supervisor _____			
QC / QA Coordinator _____															



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044781



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Bejenaru, Livia

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044781
PO Date: 10/16/19
Due Date: 11/4/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
2019-10-18

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199051	RBW6510G06531-6F-2	RBW6510G06531-6F Rev A	Support #1 1-Issue P/O Heat treat RC 28-32 2-Bead blast - parts to be lightly oiled after bead blast 3-Material type 4140 4-Certificate of Conformity is required	Firmed	-	11/4/19	7 pcs	0 pcs	7 pcs	\$52.4321/pcs	\$367.02
2	199052	RBW6510G06531-6F-3	RBW6510G06531-6F Rev A	Support #2 1-Issue P/O; Heat treat RC 28-32 2-Bead blast - parts to be lightly oiled after bead blast 3-Material type 4140 4-Certificate of Conformity is required	Firmed	-	11/4/19	7 pcs	0 pcs	7 pcs	\$52.4321/pcs	\$367.02



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER

POHB044781



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	200368	8NR-49	8NR-49 Rev 2	Stiffener 2 Hole (Outsource process - Heat Treat) 1-Issue P/O to Metcore RC 45-50 2-Bead blast 3-Material 4140 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/4/19	10 pcs	0 pcs	10 pcs	\$31.40/pcs	\$314.00
4	200355	846.3013	846.3000 Rev N/C	Blade : Various STC's ISSUE P/O: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS As Per Dwg 846.3000 PART ARE MADE FROM AISI A2 TOOL STEEL	Firmed	-	11/4/19	20 pcs	0 pcs	20 pcs	\$7.6585/pcs	\$153.17
5	200358	846.3014	846.3000 Rev N/C	Blade : Various STC's ISSUE P/O: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS As Per Dwg 846.3000 PART ARE MADE FROM AISI A2 TOOL STEEL HEAT TREAT AS PER DWG, SEE NOTE #3	Firmed	-	11/4/19	21 pcs	0 pcs	21 pcs	\$7.6585/pcs	\$160.83



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044781



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	199032	RBW6500G04231-3G-2	RBW6500G04231-3G Rev B	Base 1-Issue P/O Heat treat RC 28 32 2-Bead blast 3-Apply LPS-3 rust inhibitor 4-Material type 4140 5-Certificate of Conformity is required	Firmed	-	11/4/19	6 pcs	0 pcs	6 pcs	\$52.3333/pcs	\$314.00
Grand Total:												\$1,676.05

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/18/19 11:39 AM Dart.Guerin.Kimberley

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
340082	1	141213

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À / Shipped To

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
HB044781		4140	2019/10/16	client

QUANTITÉ Quantity	No. PIÈCE Part No.	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
----------------------	-----------------------	------------------------------	---	-----------------

14 RBW6510G06531-6F-2 469,
(7) RBW6510G06531-6F-2
JOB 199051
(7) RBW6510G06531-6F-3
JOB 199052

DAS
81
9-89

1 BOITE DE BOIS

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE BOIS	1	

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 14

POIDS EXPÉDIÉ / Weight Shipped : 469,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

RECEIVED

NOV 04 2019

DART AEROSPACE LTD.

APPROUVÉ
[Signature]

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 14

POIDS EXPÉDIÉ / Weight Shipped : 469,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2019/11/01

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
340082	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB044781	N/A	4140		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SEL HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	26 - 32 HRC	14 (907)	26 - 32 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
14	469	RBW6510G06531-6F-2 (7) RBW6510G06531-6F-2 JOB 199051 (7) RBW6510G06531-6F-3 JOB 199052 1 BOITE DE BOIS		

COMMENTAIRES / comments

SALT HARDEN 1550°F - 1:15 HRS

SNAP TEMPER 400°F - 2:00 HRS

TEMPER 1100°F - 5:00 HRS

GLASS BEAD

OIL

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification.

All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
340082	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

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APPROUVÉ par / Approved by:

DATE: 2019-11-01

Lucie Desmarais
QA Technician



METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél : 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
340082	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB044781	N/A	4140		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SEL HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	26 - 32 HRC	14 (907)	26 - 32 HRC DAS 81 E-80

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
14	469	RBW8510G08531-8F-2 (7) RBW8510G08531-8F-2 JOB 199051 (7) RBW8510G08531-8F-3 JOB 199052 1 BOITE DE BOIS

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

Alexandre Domyga



DATE: 2019-11-01

APPROUVÉ
[Signature]



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045129**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3866
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045129

PO Date: 11/18/19

Due Date: 11/26/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-20

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198991	RBW6510G05431-6F	RBW6510G05431-6F Rev A	Wrench Assembly #2 -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required	Firmed	-	11/26/19	2 pcs	0 pcs	2 pcs	\$4.35/pcs	\$8.70
2	202116	RB T101530-19	RB T101530 Rev A	Base Outside Processing - Black Oxide -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/26/19	4 pcs	0 pcs	4 pcs	\$4.55/pcs	\$18.20



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PURCHASE ORDER POHB045129



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	201161	RBT18520-5	RBT18520 Rev Q	Weldment -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/26/19	8 pcs	0 pcs	8 pcs	\$2.25/pcs	\$18.00
4	200301	RBE350A94-3700-B-05	RBE350A94-3700-B Rev 6	Foot Outsource12 (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/26/19	36 pcs	0 pcs	36 pcs	\$1.97/pcs	\$70.92
	200302				Firmed	-	11/27/19	37 pcs	0 pcs	37 pcs	\$1.97/pcs	\$72.89
Sub Total:								73	0	73		\$143.81
5	201162	RBT18520-7	RBT18520 Rev Q	Pivot Bar Weldment -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MIL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Steel -Certificate of Conformity is required	Firmed	-	11/26/19	6 pcs	0 pcs	6 pcs	\$4.70/pcs	\$28.20



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PURCHASE ORDER POHB045129



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	199052	RBW6510G06531-6F-3	RBW6510G06531-6F Rev A	Support #2 -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/26/19	7 pcs	0 pcs	7 pcs	\$14.75/pcs	\$103.25
7	199051	RBW6510G06531-6F-2	RBW6510G06531-6F Rev A	Support #1 -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/26/19	7 pcs	0 pcs	7 pcs	\$14.75/pcs	\$103.25
8	200898	RB23005023-1	RB23005023 Rev 1	Support -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/26/19	4 pcs	0 pcs	4 pcs	\$2.95/pcs	\$11.80



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PURCHASE ORDER **POHB045129**



Items

Line	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	200900	RB23005023-3	RB23005023 Rev 1	Ring -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/26/19	6 pcs	0 pcs	6 pcs	\$3.15/pcs	\$18.90
Grand Total:											\$454.11	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/20/19 9:28 AM Dart.Guerin.Kimberley

**Certificat de Conformité / Certificate of Compliance**
(024203-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupealtech.com

Bon de Livraison / Packing Slip**024203 - 1**

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
22-Nov-2019		Jigar Patel				POHB045129				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC Qty	Qté Scrap	À venir / Back Order		
8	RBW6510G06531-6F-2 Rev.A	RBW6510G06531-6F OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	7	7	0	0	0		
9	RB23005023-1 Rev.1	RB23005023 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0		
10	RB23005023-3 Rev.1	RB23005023 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0		

RECEIVED
NOV 25 2019
DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Épaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.

**Certificat de Conformité / Certificate of Compliance**
(024203-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupepaltech.com

Bon de Livraison / Packing Slip**024203 - 1**

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No				
22-Nov-2019		Jigar Patel		POHB045129				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6510G05431-6F Rev.A	RBW6510G05431-6F OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	2	2	0	0	0
2	RB T101530-19 Rev.A	RB T101530 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0
3	RBT18520-5 Rev.Q	RBT18520 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	8	8	0	0	0
4	RBE350A94-3700-B-05 Rev.6	RBE350A94-3700-B 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS1	OXIDE-BLACK CH	36	36	0	0	0
5	RBE350A94-3700-B-05 Rev.6	RBE350A94-3700-B 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS1	OXIDE-BLACK CH	37	37	0	0	0
6	RBT18520-7 Rev.	RBT18520-7 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0
7	RBW6510G06531-6F-3 Rev.A	RBW6510G06531-6F OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	7	7	0	0	0

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NOV 25 2019

DART AEROSPACE LTD.